

Work Order ID 164916***164916***

Page 1

Wednesday, August 09, 2017 2:41:44 PM

Item ID: D3500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle

Start Date: 7/31/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 8/9/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

AUG 03 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3500

C

100

2.84

100

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

10.19

HAAS CNC vertical machine #1

Program Batch No. B164916 Double check by: De 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine
Step No 3 per Folio FA641 and inspect p

40

Ø

DAS
1
9-89

17-08-13

110

QC1- Inspection performed by CMM

0.00

110

QC

Memo

0.40

Quality Control

Inspect on CMM as per folio CMMA031.
DWG REV: C
CMM PROG. REV: _____

40

Ø

DAS
1
9-89

17-08-13

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.80

Quality Control

40

Ø

DAS
44
9-89

17-08-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER :					
☐ Misidentified	☐ Past Due						

Work Order ID 164916

Wednesday, August 09, 2017 2:41:44 PM

164916

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 7/31/2017 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 8/9/2017 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 2.23				<u>40</u>	<u>0</u>	<u>2017-08-31</u>	<u>JSC</u> <u>BEB</u>
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <u>M 138014.</u> Memo START TIME: <u>2:40</u> OVEN TEMPERATURE: <u>300</u> FINISH TIME: <u>3:10</u>	0.00 1.23				<u>40</u>	<u>0</u>	<u>17-08-31</u>	<u>338</u> <u>9-89</u>
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.40				<u>40</u>			<u>DAS</u> <u>38</u> <u>9-89</u> <u>SEP 01 2017</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Work Order ID 164916

Wednesday, August 09, 2017 2:41:44 PM

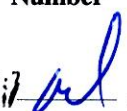
164916

Page 3

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 7/31/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 8/9/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST403	0.00							
160									
Packaging	Memo	0.40							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	4.00							
Quality Control									

DAS
6
9-89**40** SEP 07 2017 **17/9/8** DAS
21
9-89

SEP 07 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, August 09, 2017 2:41:44 PM

Page 1

Work Order ID: 164916

164916

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 7/31/2017

Required Date: 8/9/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	56.0000	1	40			
D6102-013									**				
Saddle Billet													

DAS
1
9-89

17-08-13

Location

Loc Qty

Loc Code

MAT046

56

→ 164014

56

40

DQA: _____ Date: _____

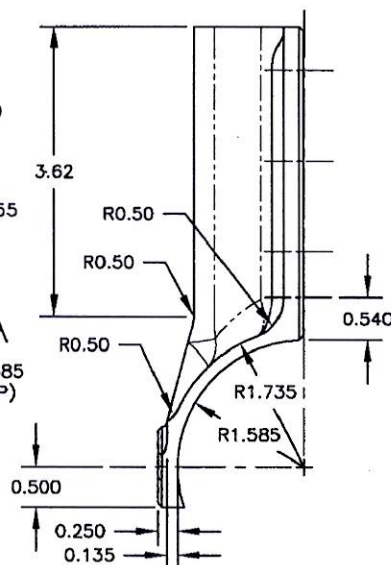
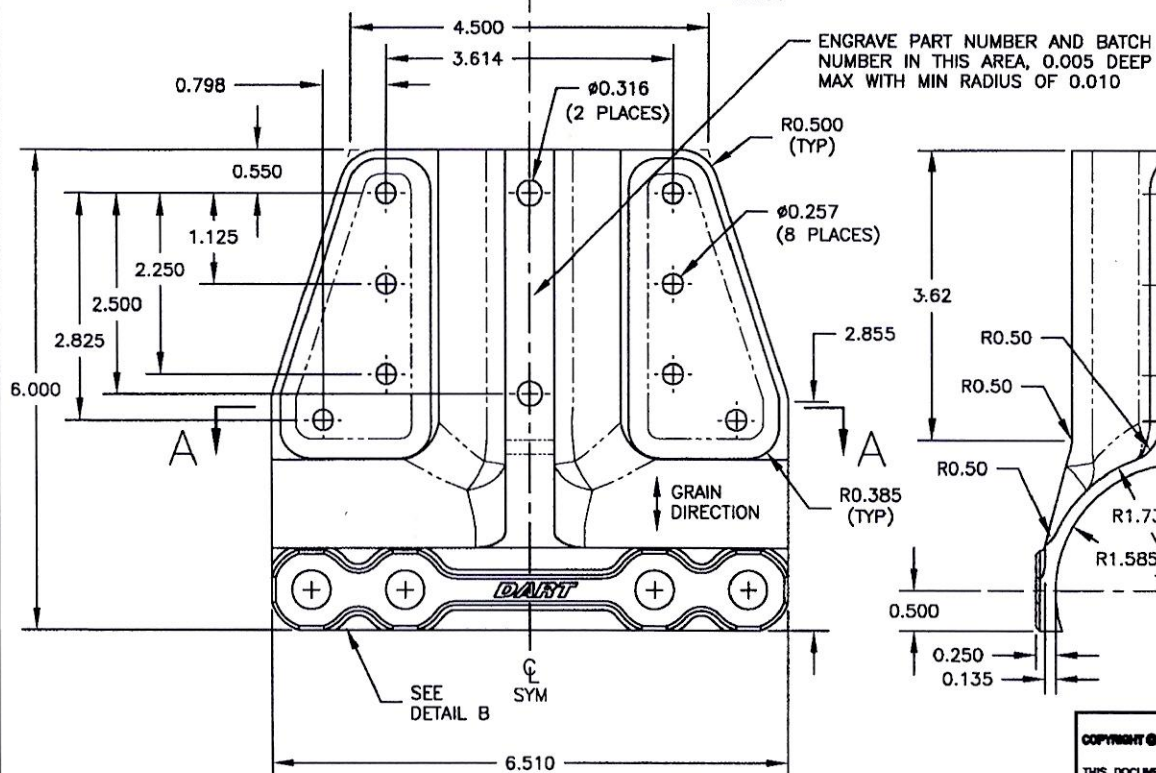
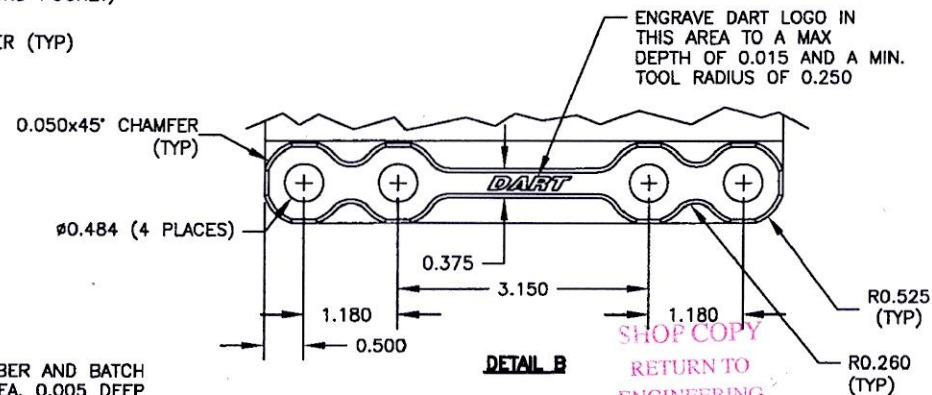
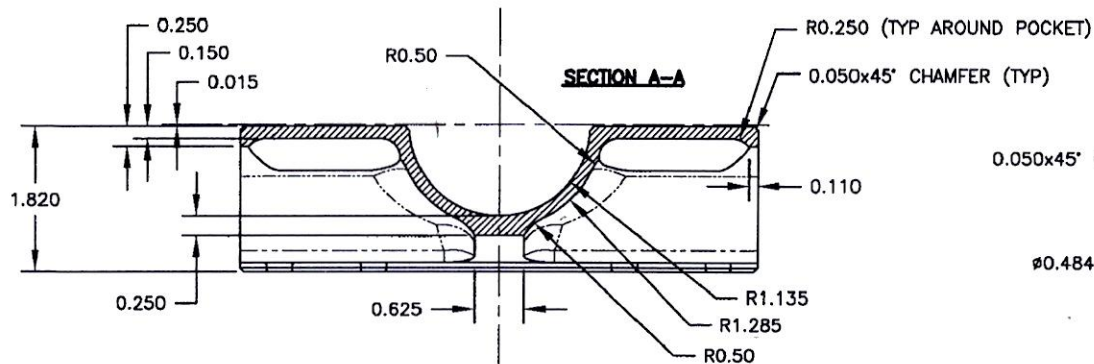


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-68-15 #

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
DART AEROSPACE LTD.		REV. C
DART AEROSPACE LTD.		SHEET 1 OF 1
DART AEROSPACE LTD.		SCALE
DART AEROSPACE LTD.		2-3

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DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490	Pin 484	0.485	0.485	0.485	0.485	0.485
B	1.175	1.185	1	1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.582	1.581	1.582	1.587
J	0.240	0.260		0.252	0.252	0.252	0.254	0.254
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322	Pin 316	0.316	0.316	0.316	0.316	0.316
N	0.256	0.262	Pin 257	0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.545	0.545	0.545	0.546	0.545
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.254	0.253	0.254	0.252	0.252
AE	1.810	1.830		1.821	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.140	0.160		0.152	0.150	0.152	0.152	0.151
AH	0.140	0.160		0.155	0.153	0.154	0.152	0.153
AI	0.140	0.160		0.154	0.153	0.152	0.152	0.151

DAS
↑
Accept/Reject

Measured by: 9-89	Date: 17-08-13
Audited by: FK	Date: 17-08-18
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#6	#7	#8	#9	#10
A	0.483	0.490		0.485	0.485	0.485	0.485	0.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.582	1.581	1.580	1.582	1.582
J	0.240	0.260		0.254	0.253	0.253	0.254	0.253
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.126	1.125	1.125	1.126
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.256	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.35
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.253	0.254	0.254	0.253	0.253
AE	1.810	1.830		1.820	1.820	1.820	1.821	1.820
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.249
AG	0.140	0.160		0.153	0.152	0.153	0.152	0.152
AH	0.140	0.160		0.152	0.153	0.152	0.150	0.153
AI	0.140	0.160		0.152	0.152	0.152	0.152	0.152

DAS Accept/Reject

✓ ✓ ✓ ✓ ✓

Measured by:	1	Date:	17-08-17
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Audited by:	FR-89	Date:	17-8-18
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.483	0.490		.485	.485	.485	.485	.785
B	1.175	1.185		1.180	1.179	1.179	1.179	1.179
C	3.145	3.155		3.149	3.148	3.148	3.148	3.148
D	1.175	1.185		1.180	1.180	1.180	1.180	1.179
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.499	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.584	1.584	1.585	1.587	1.586
J	0.240	0.260		.251	.253	.253	.253	.252
K	0.490	0.510		.500	.500	.499	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.545	.550	.545	.545	.548
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		R.250	R.250	R.250	R.250	R.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.130	1.130	1.130	1.132	1.132
AB	R.490	R.510		R.500	R.500	R.500	R.500	R.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.253	.253	.252	.252	.253
AE	1.810	1.830		1.820	1.821	1.820	1.822	1.822
AF	0.240	0.260		.249	.249	.248	.251	.249
AG	0.140	0.160		.150	.150	.149	.152	.150
AH	0.140	0.160		.151	.151	.150	.151	.152
AI	0.140	0.160		.151	.152	.153	.152	.151
Accept/Reject				A	A	A	A	A

Measured by: <u>SL</u>	Date: <u>17/08/15</u>
Audited by: <u>FK</u>	Date: <u>17-08-18</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.179	1.180	1.179	1.179	1.179
C	3.145	3.155		3.148	3.148	3.148	3.148	3.148
D	1.175	1.185		1.179	1.180	1.180	1.179	1.179
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.499	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.586	1.585	1.584
J	0.240	0.260		.252	.252	.252	.252	.253
K	0.490	0.510		.499	.500	.500	.499	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.548	.548	.546	.546
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.05	.05	.05	.05	.05
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.131	1.131	1.131	1.131	1.130
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.252	.252	.250	.252	.253
AE	1.810	1.830		1.821	1.821	1.821	1.821	1.820
AF	0.240	0.260		.249	.249	.249	.249	.248
AG	0.140	0.160		.150	.150	.150	.149	.149
AH	0.140	0.160		.152	.152	.152	.152	.153
AI	0.140	0.160		.151	.152	.152	.153	.153
Accept/Reject				A	A	A	A	A

Measured by: <u>SC</u>	Date: <u>17/08/16</u>
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Audited by: <u>FK</u>	Date: <u>17-08-18</u>
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.179	1.179	1.179	1.179	1.179
C	3.145	3.155		3.148	3.149	3.148	3.148	3.148
D	1.175	1.185		1.179	1.179	1.179	1.180	1.179
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.500	.500	.501	.501	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.586	1.586	1.585	1.586
J	0.240	0.260		.252	.252	.252	.259	.252
K	0.490	0.510		.499	.499	.500	.500	.499
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.546	.546	.546	.546	.546
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.132	1.132	1.132	1.131	1.131
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.253	.251	.251	.253	.252
AE	1.810	1.830		1.821	1.822	1.822	1.822	1.822
AF	0.240	0.260		.248	.251	.250	.249	.248
AG	0.140	0.160		.149	.152	.151	.149	.149
AH	0.140	0.160		.152	.152	.152	.151	.151
AI	0.140	0.160		.152	.152	.152	.151	.152

Accept/Reject

A A A A A

Measured by: J.C. Date: 10/08/16

Audited by: EK Date: 12-08-18

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26 ±	27 ±	28 ±	29 ±	30 ±
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.179	1.179	1.180	1.180	1.180
C	3.145	3.155		3.148	3.149	3.150	3.150	3.150
D	1.175	1.185		1.179	1.179	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.501	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.586	1.582	1.585	1.583
J	0.240	0.260		0.252	0.252	0.252	0.253	0.252
K	0.490	0.510		0.500	0.499	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.545	0.545	0.545	0.545	0.545
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.05	0.05	0.050	0.050	0.050
Y	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AA	R1.125	R1.145		1.132	1.132	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.252	0.252	0.252	0.253	0.252
AE	1.810	1.830		1.821	1.821	1.820	1.821	1.821
AF	0.240	0.260		0.249	0.249	0.250	0.250	0.250
AG	0.140	0.160		0.150	0.149	0.150	0.150	0.149
AH	0.140	0.160		0.150	0.151	0.152	0.153	0.153
AI	0.140	0.160		0.153	0.153	0.154	0.154	0.152

Accept/Reject

A A A A A

Measured by:	DAS 1	Date:	17-08-17
Audited by:	9-89 F.K	Date:	17-08-18
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				31	32	33	34	35
A	0.483	0.490		0.485	0.485	0.485	0.485	0.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.581	1.582	1.582
J	0.240	0.260		0.253	0.253	0.252	0.252	0.252
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.545	0.545	0.545	0.545	0.545
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AE	1.810	1.830		1.821	1.821	1.820	1.821	1.821
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.140	0.160		0.153	0.152	0.152	0.152	0.152
AH	0.140	0.160		0.152	0.153	0.153	0.153	0.152
AI	0.140	0.160		0.153	0.152	0.153	0.153	0.153

Accept/Reject

Measured by: DAS	Date: 17-08-17
Audited by: 9-89 F.K	Date: 17-08-18
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				36	37	38	39	40
A	0.483	0.490		0.485	0.485	0.485	0.485	0.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.582	1.585	1.584	1.585	1.585
J	0.240	0.260		0.253	0.253	0.253	0.253	0.252
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.545	0.545	0.545	0.545	0.545
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.250	0.250	0.253	0.252	0.253
AE	1.810	1.830		1.821	1.821	1.820	1.821	1.821
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.140	0.160		0.152	0.152	0.152	0.152	0.152
AH	0.140	0.160		0.153	0.153	0.153	0.152	0.153
AI	0.140	0.160		0.153	0.153	0.152	0.153	0.152
Accept/Reject				A.	A.	A.	A.	A.

Measured by: DAS	Date: 17-08-17
Audited by: 9-89 F.R.	Date: 17-08-18
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	